

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028472**Date Inspected:** 22-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This Quality Inspector (QA) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Rodney Patterson-

Performed QA Ultrasonic Testing verification at various locations

OBG 13E-E2.2, 1 reject discovered

Fritz Belford-

Observation of welding, QC inspection and testing of the floor beams and excavations, repair welding, QC inspection and testing.

OBG 12W-W2.1-A1

Matt Daggett-

Observation of welding, QC inspection and testing of floor beams and excavations, repair welding, QC inspection and testing of floor beams.

13W-pp124-W2.2-BF1-Repair

13W-pp122-W2.1-BR1-Fit/Weld

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13W-122.5-W2.1-BR1-Fit/Weld

Doug Frey-

Observation of excavations, repair welding, production welding, QC inspection and testing of floor beams.

12E-pp116.5-DAH

12E-E2.1-Overhead Repair

13E-pp124.5-DAH-Repair

12E-E2.1-QCUT

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

Quality Assurance Inspector (QA) Summary

This QA Lead observed the QA Inspectors Rodney Patterson, Fritz Belford, Doug Frey and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QA Inspectors utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Inspector discussed and reviewed the work performed by the QAs in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QA observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications. There were no issues noted during this shift.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations were relevant to work performed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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